10 Um:

Each

Date: User: Monday, 04/05/2009 3:15:50 PM

Julie Dawson

#### **Process Sheet**

**Drawing Name** 

**Part Number** 

Material **Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: ARM

: D28441

: N/A

: A

: D2844 REV A

: 11/05/2009

Customer Job Number : CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

: SMALL /MED FAB

: 47728

**Estimate Number** 

: 11047

P.O. Number

This Issue

: 04/05/2009

: NC

Prsht Rev. : 11 First Issue

**Previous Run** 

: 46844

Written By

Checked & Approved By

Comment

: Est:

В 00.11.01

processEC

**Additional Product** 

Job Number:

Seq. #:

1.0

**Machine Or Operation:** 

M304TR0500W035

304 RD Tube .500 x .035W

Description:

Removed P/O for Powder Coat - in house

Comment: Qty.:

Total: 1.9941 f(s)/Unit

19.9406 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch

2.0 BRAKE NO



Comment: BAND SAW

Form per Dwg D2844 using brake and bending Jig DT 8238-B

Deburr

3.0 QC5 INSPECT WORK TO CURRENT STEP



**Comment: INSPECT WORK TO CURRENT STEP** 

4.0

POWDER COATING

**POWDER COATING** 



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

**OVEN TEMPERATURE:** 

FINISH TIME:



mh 09/05/05



Fol 09/05

## **Dart Aerospace Ltd**

	•									
W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·	
			PAR #: Fault Category: NCR: Yes No DQA: Date:  Disposition: QA: N/C Closed: Date:  WORK ORDER NON-CONFORMANCE (NCR)							
						·			Date: Date: Approval Approval Approval	
		•								
Part No:		PAR #:	Fault Cat	_ Fault Category:			lo <b>DQ</b>	DQA: Date:		
	Re	esolution:	Disposition:		QA: N/C Closed: _					
NCR:			WORK ORI	DER NON-CONFOR	RMANCE (	NCR)				
DATE	STEP	Description of NC							Approval /	Approval
		Section A						Section C		QC Inspector
						•				
				•						

	nday, 04/05/2009 3:15:50 PM			
	e Dawson	Process She		
Customer:	CU-DAR001 Dart Helicopters Serv	vices Drawing	g Name: ARM	
Job Number:	47728	Part N	lumber: D28441	
Job Number:				
Seq. #:	Machine Or Operation:		Description :	
5.0	QC3	INSPECT POWDER (	COAT/CHEMICAL CONVERSION	<i>(b)</i> .
	ent: INSPECT POWDER COAT/0		BK 09-08	5-7
6.0	QC6	DIMENSIONAL CHEC		
Comm	ent: DIMENSIONAL CHECK	dua D2044		
7.0	ensure parts are still as per of PACKAGING 1	PACKAGING RESOU	S 61/0 8</td <td>(410)</td>	(410)
Comm	ent: PACKAGING RESOURCE # Identify and Stock Location:	1 265	13	09(05/08 80
8.0	QC21	FINAL INSPECTIONA	N/O RELEASE	205/08/
Comm	ent: FINAL INSPECTION/W/O RI	ELEASE		10
Job Completion				09-05-08

#### **Dart Aerospace Ltd**

			WORK ORDER CHANGES  PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr Chart Eng / Prod Mgr C						
W/O:			WO	RK ORDER CHAN	GES				
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Chief Eng /	Approval QC Inspector
					-				
Part No:		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Disposition	QA: N/C C	QA: N/C Closed: Dat				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	3)			
DATE	STEP	Description of NC				Verification Approval Approval			
	OIL.	Section A	1	Action Description  Chief Eng			ion C	Chief Eng	
		·							
		<i>;</i>							





DESIGN	DRAWN BY	DART AEROS	SPACE USA, INC.
CHECKED	APPROVED	drawing no. D2844	REV. A SHEET 1 OF 2
DATE	7	TITLE	SCALE
98.10.14	4	ARM	1:3
Α	98.10.14	NEW ISSUE	

RELEASED 49.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727 -3.50 12.79 R8.50 - 12.85 -0.75 -SHOP COPY RETURN TO **ENGINEERING** D2844-1 UNCONTROLLED COPY SUBJECT TO AMENUMENT WITHOUT NOTICE

MATERIAL: AISI 304/316 SS TUBE, Ø0.50 x 0.035 WALLWORK OR ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

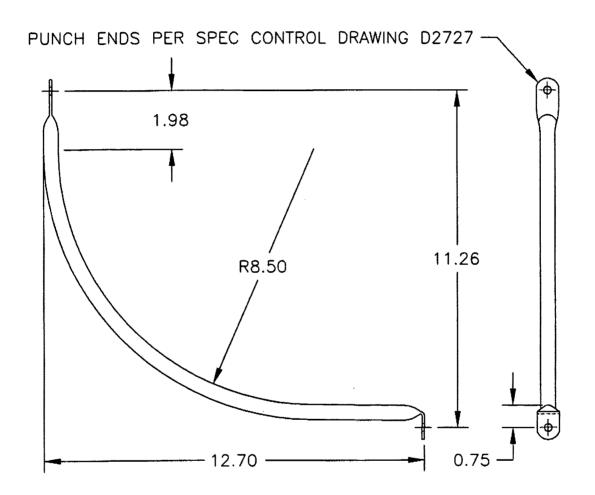
### **Dart Aerospace Ltd**

WORK (	ORDER CHANGE	S By	Date	Qty	Approval Chief Eng /	Approval		
URE CHANGE		Ву	Date	Qty	Chief Eng /			
				<del></del>	Prod Mgr	QC Inspector		
		By Date Qty Chief Eng / Prod Mgr Approval QC Inspector  NCR: Yes No DQA: Date: QA: N/C Closed: Date: ANCE (NCR)						
				1				
			NCR: Yes No DQA: Date:					
K ORDER N	ON-CONFORMAN	ICE (NCR	)					
		V			Approval	I Approval		
	Chief Eng		Section C		Chief Eng	QC Inspector		
	Disposition: RK ORDER NO Correct	Corrective Action Section  Initial Action Description	Corrective Action Section B Initial Action Description Sign &	Corrective Action Section B  Corrective Action Description Sign & Section Sect	Corrective Action Section B  Notion Description  Output  Disposition:  QA: N/C Closed:  Verification Section C.	Corrective Action Section B  Initial Action Description Sign & Verification Section C Section C		



DESIGN	DRAWN BY	DART AEROSPAC	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 2 OF 2
DATE	1/	TITLE	SCALE
98.10.14		ARM	1:3

# RELEASED



D2844-3

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WITHOUT NOTICE

MATERIAL: AISI 304/316 SS TUBE, Ø0.50 x 0.035 WALL

ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

Dart Aerospac	e:	Ltd
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No: PAR #: Resolution:									
		Disposition	_ QA: N/C C						
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	7)			
DATE	STEP	Description of NC		Corrective Action Section		Varitication			Approval
DAIL	Sec	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C	Approval Chief Eng	QC Inspecto	
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